

Work Order ID 68601

Page 1

Monday, April 18, 2011 12:38:22 PM

Item ID: D412-750-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Light Fairing, LH

Start Date: 4/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: PPDate: 4-18-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-750-141 CHG001

Sublet

JDC CL 11-4-19

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

L FB H 11/04/19

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

***** Ensure part is a L/H as per dwg *****

Sublet

x4
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68601

Page 2

Monday, April 18, 2011 12:38:22 PM

Item ID: D412-750-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Light Fairing, LH

Start Date: 4/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-750-141 141 <input type="checkbox"/> Location: <u>22</u> <input type="checkbox"/> PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/4/19 (4)

11/4/19

11-04-19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 12:38:29 PM

Page 1

Work Order ID: 68601

Parent Item: D412-750-141

Parent Item Name: Tail Light Fairing, LH

Start Date: 4/18/2011


Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 06.09.22 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-3A  Bolt		Purchased	No			120	Each	256.0000	10	40 ✓			
--	--	-----------	----	--	--	-----	------	----------	----	------	--	--	--

Location Loc Qty Loc Code

ST350 256
116924 256

AN960JD10  Washer	NAS1149D0363J	Purchased	No			120	Each	0.0000	10	40 ✓			
---	---------------	-----------	----	--	--	-----	------	--------	----	------	--	--	--

D3484-041  Tail Light Fairing Assembly, LH		Manufactured	No			120	Each	4.0000	1	4 ✓			
--	--	--------------	----	--	--	-----	------	--------	---	-----	--	--	--

Location Loc Qty Loc Code

ST205 4
66014 4

116924

116583 JB

11/04/19

66014

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

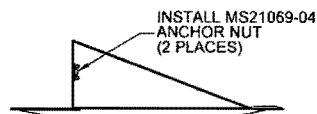
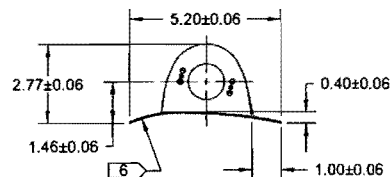
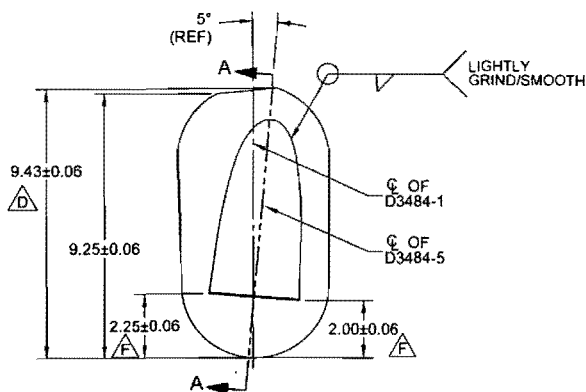
4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141 <i>Tail Light Fairing Kit, LH</i>	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m
D412-750-142 <i>Tail Light Fairing Kit, RH</i>	0.13 lb 0.06 kg	6.0 in 0.2 m	0.78 lb-in 0.01 kg-m	296.1 in 7.5 m	38.49 lb-in 0.45 kg-m

5.0 PARTS LIST

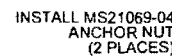
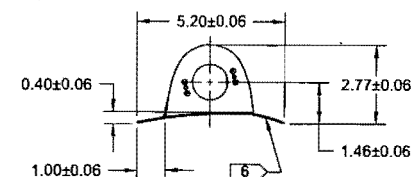
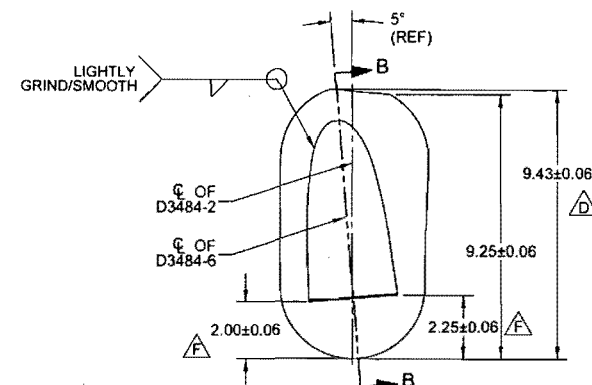
Qty - 141	Qty - 142	Part Number	Description
X		D412-750-141	TAIL LIGHT FAIRING KIT, LH
	X	D412-750-142	TAIL LIGHT FAIRING KIT, RH
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER



SECTION A-A

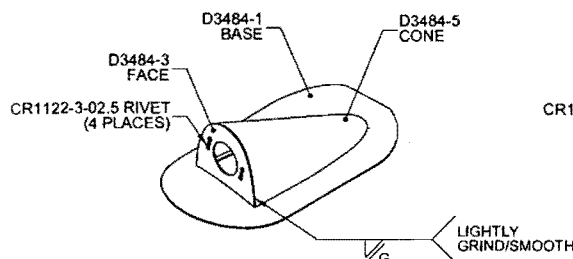
D3484-041 TAIL LIGHT FAIRING

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
1	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
1		D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
1		D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

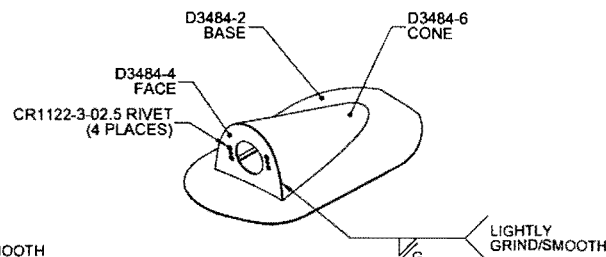


SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) WELDING: PER DART QSI 004
 - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE POA06-13"
 - 7) WEIGHT: 0.30 lbs

RELEASED
09/03/31

REV.	DESCRIPTION	BY	DATE
F	UPDATE MATERIAL SPEC, ADD 6081-0, ZN A7-2, A7-3, B3-4, UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	RE-DRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY, CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3484		REV. F	
TITLE TAIL LIGHT FAIRING		SHEET 1 OF 4	
COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		SCALE 1:4	

REFERENCE ONLY